

Work Order ID 121294

Friday, June 20, 2014 1:36:34 PM

ASAP
121294

SEE Attached Email

Page 1

Item ID: D4895-043
Revision ID:
Item Name: Aft Outboard Beam Assembly
Start Date: 6/23/14 Start Qty: 6.00
Required Date: 7/04/14 Req'd Qty: 6.00
Reference:

Accept

N900040100

U/R
Setup Start ***NS1***
Stop ***NS2***

Cust Item ID:
Customer:

**A* (u)*
A

Approvals: Process Plan: *AA* Date: 14-6-20 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D4895	A U/R	

OK per attached email

100 0.00
100
Waterjet Memo 0.00
FLOW CNC Waterjet CUT BLANK AS PER FILE D4895-3_BLANK
6061 6.00" x 12.00"

2 EL / 4-6-24
(4) mm 14/07/03

110 0.00
110
HAAS 1 Memo 0.00
HAAS CNC vertical machine #1 MILL AS PER FOLIO FB194 AND DWG D4895
FOLIO REV: AA
DWG REV: A
DEBURR

OK 14/07/05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 121294

121294

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Friday, June 20, 2014 1:36:34 PM

Item ID: D4895-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Outboard Beam Assembly
 Start Date: 6/23/14 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 7/04/14 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *100* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 27 9-89 14/7/8				6			
200 *200* Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 376 81477 0.00 PPPD2274				6x.		14-7-9	DAS 26 9-89
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MLS		14-07-09	

14-7-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 1
1

Work Order ID: 121294

121294

Parent Item: D4895-043

D4895-043

Parent Item Name: Aft Outboard Beam Assembly

Start Date: 6/23/14

Required Date: 7/04/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 13-05-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X12.00 0		Purchased		No			f	16.6400		19			

M6061T6B1 000X12 000

6061-T6 Bar 1.00 x 12.00

EL 14-6-24

Location

Loc Qty

Loc Code

MAT005

16.64

116406

8

123649

2

M126075

5.64

M126351

1

Each

6,732.000

24

6.16

6.16

DAS
36
9-89

14/07/08

MS20426AD3-5

Purchased

No

MS20426AD3-5

Rivet

Location

Loc Qty

Loc Code

GA

4818

4533

4818

ST334

1914

4444

1914

Each

50.0000

12

M120123 (24)

DAS
36
9-89

14/07/08

MS21059L4

Purchased

No

MS21059L4

Nutplate

Location

Loc Qty

Loc Code

GA

10

125535

10

ST316

40

m128401

15

m129022

25

12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

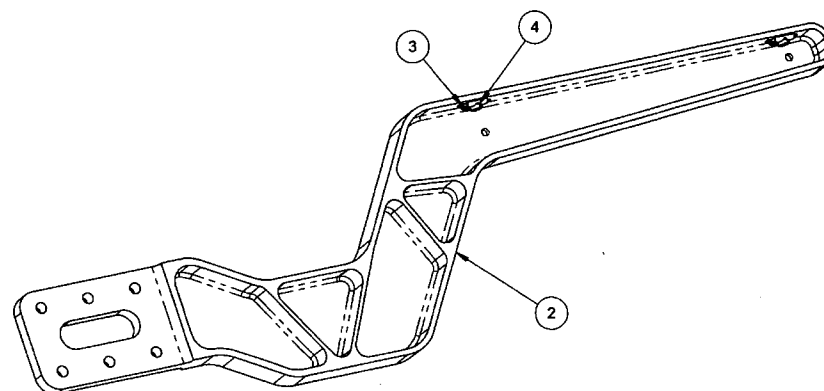
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4895-041	FWD OUTBOARD BEAM ASSY
2	1	D4895-1	FWD OUTBOARD BEAM
3	4	MS20426AD3-(5)	RIVET
4	2	MS21059L4	ANCHOR NUT



D4895-041 FWD OUTBOARD BEAM ASSY





SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121294
14-6-20

UNDER REVIEW
14.06.05

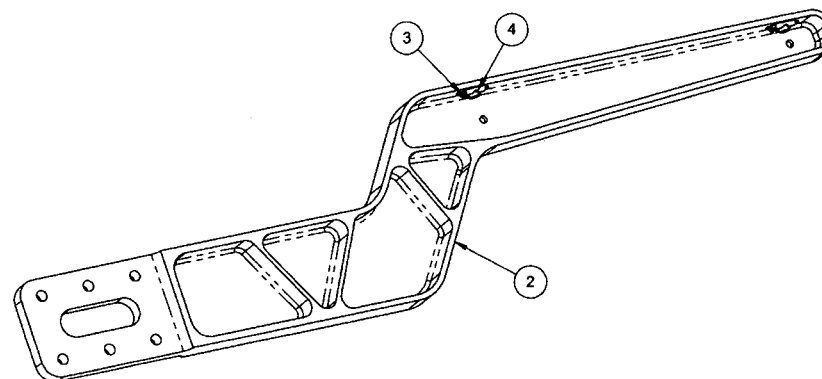
RELEASED
2013-06-12
W

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.31 lbs

A	NEW ISSUE		RF	13.05.24
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4895 TITLE OUTBOARD BEAM	REV. A	
DRAWN	RF		SHEET 1 OF 5	
CHECKED			SCALE	
MFG. APPR.			NTS	
APPROVED				
DE APPR.				
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4895-043	AFT OUTBOARD BEAM ASSY
2	1	D4895-3	AFT OUTBOARD BEAM
3	4	MS20426AD3-(5)	RIVET
4	2	MS21059L4	ANCHOR NUT



D4895-043 AFT OUTBOARD BEAM ASSY

UNDER REVIEW

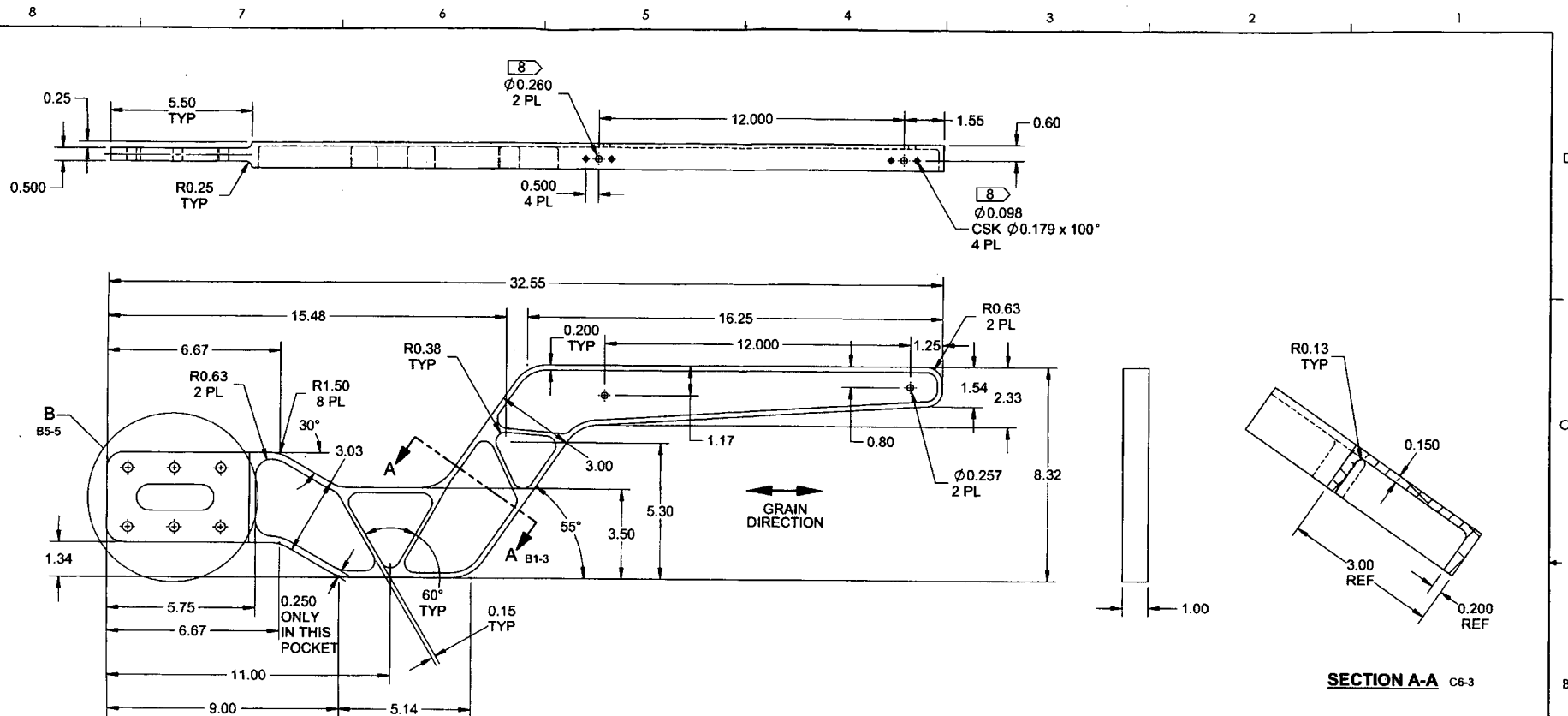
14.06.05

RELEASED
2013-06-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.25 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4895	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OUTBOARD BEAM	NTS
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D4895-1 FWD OUTBOARD BEAM

UNDER REVIEW

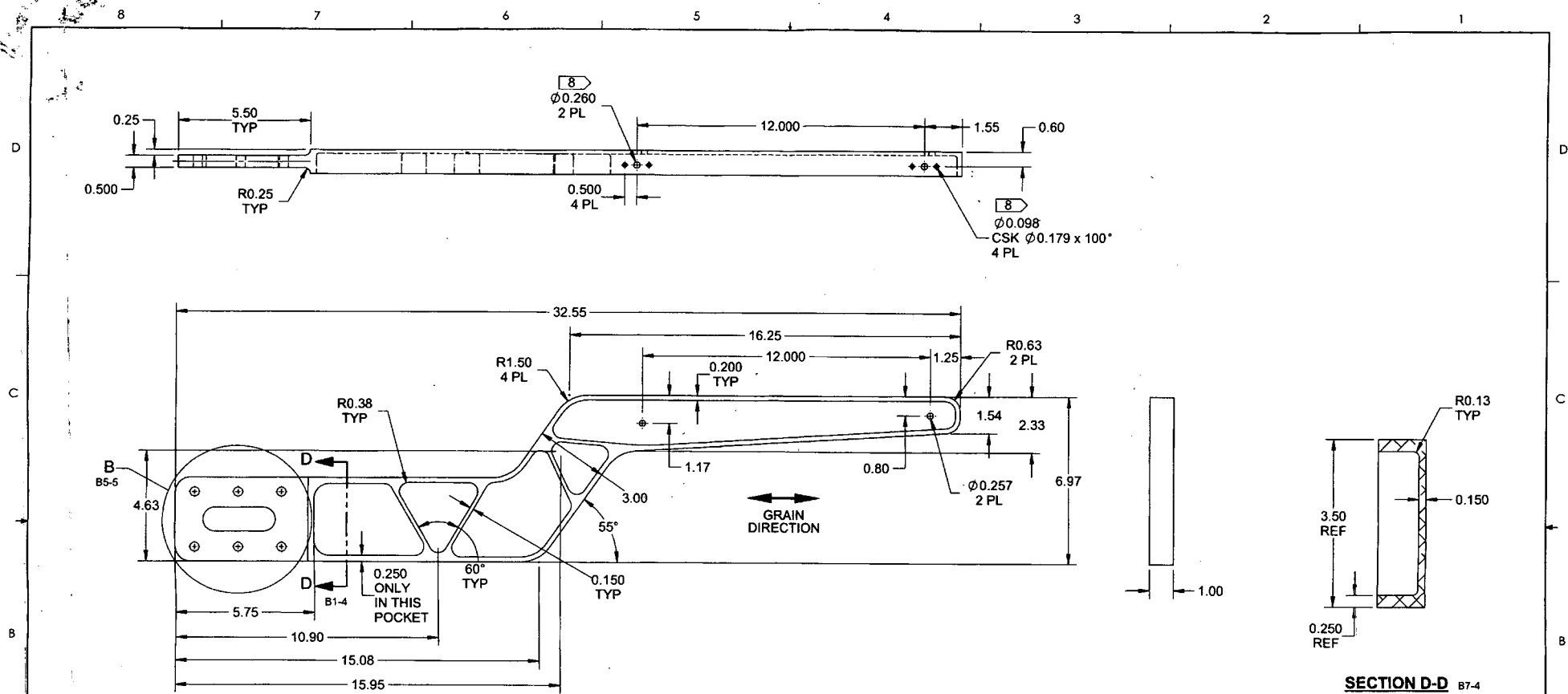
14.06.05

RELEASED
2013-06-12

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.30 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4895	SHEET 3 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD BEAM	NTS
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D4895-3 AFT OUTBOARD BEAM

NOTES:

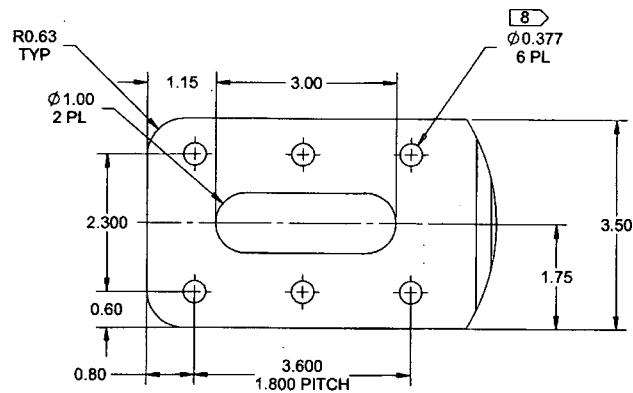
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.25 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

UNDER REVIEW

14.06.05

RELEASED
2013-06-12

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4895	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OUTBOARD BEAM	NTS
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DETAIL B C8-3
C8-4

RELEASED
2013-06-12
14.06.05

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4895	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OUTBOARD BEAM	NTS
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Mario Poulin

From: Harvey Siemens
Sent: Friday, June 20, 2014 3:03 PM
To: Linda Lacelle
Cc: Mario Poulin
Subject: RE: NEW SO117104 FOR HELI NIUGINI - ALISON

Linda,

OK to manufacture D117-837 baskets that are under review believing that the customer doesn't want the quick release version.

Regards,

Harvey

From: Linda Lacelle
Sent: June-20-14 12:51 PM
To: Harvey Siemens
Cc: Mario Poulin
Subject: FW: NEW SO117104 FOR HELI NIUGINI - ALISON

Harvey,

Just received an order for 2 x 117 baskets, current style, D4894-1/-3 & D4895-041/043 are in the U/R folder, can you pls send this email back saying ok to mfg, so I can proceed with production?

Thx

L

From: Alison Markus
Sent: June-20-14 9:47 AM
To: Linda Lacelle; Nancy MacLeod; Melanie Fauteux; Ruth Molnar; Brigitte Golden; Mario Poulin
Cc: Shirley Hay; Linda Pilon; Chantal Chartrand; Diana Hagen; Carrie Pearson; Jean Kerr
Subject: RE: NEW SO117104 FOR HELI NIUGINI - ALISON

Old version

ALISON MARKUS
Sales Representative



From: Linda Lacelle
Sent: June 20, 2014 9:46 AM
To: Nancy MacLeod; Melanie Fauteux; Ruth Molnar; Brigitte Golden; Mario Poulin
Cc: Shirley Hay; Linda Pilon; Chantal Chartrand; Diana Hagen; Carrie Pearson; Jean Kerr; Alison Markus
Subject: RE: NEW SO117104 FOR HELI NIUGINI - ALISON

Is this at the new CHG or the current change pls??

DART AEROSPACE LTD	Work Order: 121294
Description: AFT OUTBOARD BEAM	Part Number: D4895-3
Inspection Dwg: D4895 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.25	$\pm .030$.242	—		Vern	ML-06
.500	$\pm .010$.503	—		"	
5.50	$\pm .030$	5.500	—		"	
$\phi .260$	$\pm .005$ $\pm .001$	$\phi .261$	—		"	
12.000	$\pm .005$	12.000	—		"	
1.55	$\pm .030$	1.550	—		"	
.60	$\pm .030$.600	—		"	
$\phi .098$	$\pm .005$ $\pm .001$	$\phi .098$	—		"	
$\phi .179 \times 100^\circ$	$\pm .005 \times \pm 1/2^\circ$	$\phi .179 \times 100^\circ$	—		"	
.500	$\pm .005$.500	—		"	
R.25	$\pm .030$	R.250	—		R-6	
R.38	$\pm .030$	R.375	—		"	
32.55	$\pm .030$	32.550	—		M-tape	ML-08
12.000	$\pm .005$	12.000	—		"	
.200	$\pm .010$.200	—		"	
1.25	$\pm .030$	1.250	—		"	
6.97	$\pm .030$	6.971	—		"	
$\phi .257$	$\pm .005$ $\pm .001$	$\phi .257$	—		"	
.80	$\pm .030$.795	—		"	
1.17	$\pm .030$	1.170	—		"	
3.00	$\pm .030$	3.000	—		"	
55°	$\pm 1/2^\circ$	55°	—		C-Aquare	
.250	$\pm .010$.250	—		Vern	ML-06

Measured by: <i>AK</i>	Audited by: <i>SL</i>	Preliminary Approval:
Date: 14/07/05	Date: 14-7-7	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD	Work Order:	121244
Description: AFT OUTBOARD BEAM	Part Number:	D4895-3
Inspection Dwg: D4895 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.75	$\pm .030$	5.750	—		Vern	ML-06
3.50	$\pm .030$	3.498	—		"	
.150	$\pm .010$.153	—		"	
R.13	$\pm .030$	R.125	—		R-G	
Ø1.00	$\pm .030$	Ø1.000	—		Vern	ML-06
1.15	$\pm .030$	1.150	—		"	
3.00	$\pm .030$	3.000	—		"	
Ø.377	$\pm .005$	Ø.377	—		pin gage	
1.75	$\pm .030$	1.750	—		Vern	ML-06
3.600	$\pm .005$	3.600	—		"	
1.800	$\pm .005$	1.800	—		"	
.80	$\pm .030$.800	—		"	
.60	$\pm .030$.600	—		"	
2.300	$\pm .005$	2.300	—		"	

Measured by: <i>AK</i>	Audited by: <i>SL</i>	Preliminary Approval:
Date: 14/07/05	Date: 14-7-7	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15